Date:

Thursday, 5/10/2007 2:24:09 PM

User: Kim Johnston **Process Sheet Drawing Name** : FRAME : CU-DAR001 Dart Helicopters Services Customer Job Number : 32272A **Estimate Number** : 10300 Part Number : D32241 P.O. Number . D3224 REV A **Drawing Number** : 5/10/2007 S.O. No. : This Issue : N/A Project Number Prsht Rev. : NC : A : // : MACHINED PARTS **Drawing Revision** Type First Issue : 29383A Material Previous Run 6/10/2007 Qty: 4 Um: Each **Due Date** Written By Checked & Approved By 05-11-06 JLM : Est Rev:A New Issue Comment Est: B 06.11.15 waterjet EC **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M2024T3S063 2024-T3 .063 sheet 1.0 21.8400 sf(s) Comment: Qty.: Total: 5.4600 sf(s)/Unit 2024-T3 .063 thick aluminum sheet Batch: FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3224 Dwg Rev:\_\_ Prog Rev:\_\_\_\_\_ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 4.0 Comment: SECOND CHECK SMALL FAB 1 5.0 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Dart Ae	rospace l	Ltd							
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
					QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORE	DER NON-CONFORMAN	ICE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		- Verifi	cation	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
							1		

NOTE: Date & initial all entries

Date: User:

Thursday, 5/10/2007 2:24:09 PM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME

Job Number: 32272A

Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

**BRAKE NO** 

NC BRAKE

Comment: NC BRAKE

Form as per Dwg D3224

7.0

INSPECT WORK TO CURRENT STEP





Comment: INSPEC WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

QC3 9.0



INSPECT POWDER COAT/CHEMICAL CONVERSION





Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

11.0

FINAL INSPECTION/W/O.RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace l	Ltd									
W/O:			W	ORK ORDER CHANGES	3						
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _			
					QA: N/	C Close	d:	Date: _			
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR	)					
		Description of NC		Corrective Action Section I	3	Verifi	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Section C				Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32272A	
Description: Frame	Part Number:	D3224-1	
Inspection Dwg: D3224 Rev: A		Page 1 of 1	

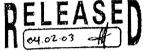
FIRST ARTICLE INSPECTION CHECKLIST								
		First Arti	cle	Prot	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
25.50	+/-0.030							
30.63	+/-0.030							
1.900	+/-0.010							
2.025	+/-0.010							
1.640	+/-0.010							
1.950	+/-0.010							
2.080	+/-0.010							
0.063	+/-0.010				٠			
2.383	+/-0.010							
,								
			·					
	1	A all the and the area	1	1 1	Dunkakuma Amm	rescale 1 NI/A		

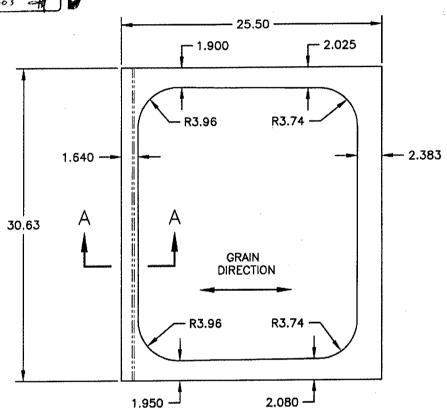
Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.10.05	New Issue	P/O D412-709-011	KJ/JLM ox	

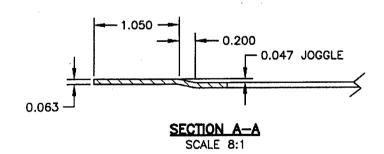


				Commence of the commence of th	
DESIG	#	DRAWN BY		AEROSPACE ESBURY, ONTARIO, CANAL	
CHECK	(ED /	APPROVED	DRAWING NO.		REV. A
1	#	1 #	D3224	•	SHEET 1 OF 1
DATE		114	TITLE		SCALE
 03.1	0.21		FRAME		NTS
Α		03.10.21	NEW ISSUE	•	





## D3224-1



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
4) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.